

Date: Monday, 06/11/2006 3:10:58 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : T-BEAM EXTRUSION
<b>Job Number</b> : 29367	
<b>Estimate Number</b> : 10043	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D6201
<b>This Issue</b> : 06/11/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D6201 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26538	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 13/11/2006 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est. A: 01.05.15 New Issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 2420

c 20611106

a) Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f) Material certification required

20 FT

m 102645

2.0	D6201P	T Extrusion 4X4X3/8
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**Comment:** Qty.: 1.0000 f(s)/Unit Total: 20.0000 f(s)

T Extrusion 4X4X3/8

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

PU 4/11/09 20 FT

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6104

RG 06.11.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: T-BEAM EXTRUSION

Job Number: 29367

Part Number: D6201

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*FD 6/11/09*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*287*  
*06/11/15*

Job Completion



*06.11.14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

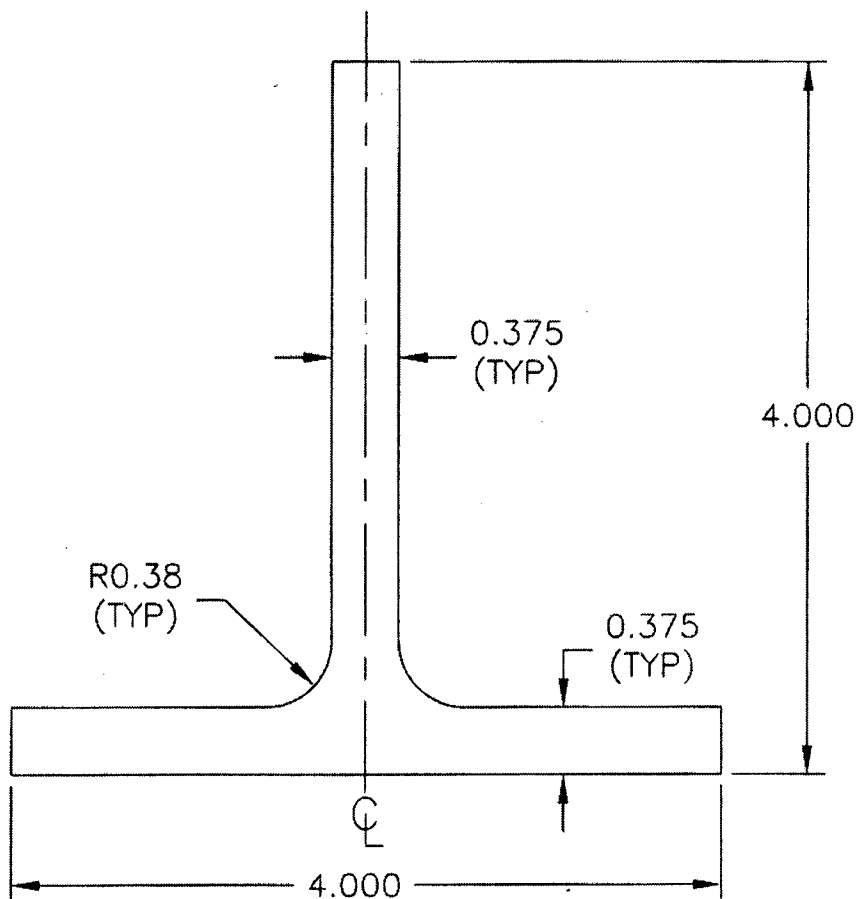
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 *[Signature]*



D6201-XXX T-BEAM EXTRUSION  
WHERE XXX IS LENGTH IN INCHES

EG.  
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET  
4.000" x 4.000" x 0.375"  
6061-T6/T6511 (QQ-A-200/8)  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

**REFERENCE ONLY**

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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PRODUCTS RECEIVED BY : .....  
NO. PKGS : .....  
SHIPPING : .....  
REF : .....

1-188-879-3742

3.

SHIP SPEC COLLECT

4/11/19

ITEM NO. DESCRIPTION ORDERED QTY DELIVERED QTY M.O.  
ALU TEE .375 X 4" X 4" 6061-T6 20  
T X 20

FAX : 1-(613)-632-4443

S A M R

DART VEROBAC LTD  
1270, VERBODEN STRAAT  
HAMERSBUKX, ONTARIO  
K6A 1K7

SHIP TO :

CUSTOMER: 6323336

ORDER # : 45122  
REFERENCE # : 400002420

METALUX SOLUTIONS  
2108 32ND AVENUE  
LACINE, QUEBEC  
H8T 3H7 TEL: (514)-633-8010

PACKING SLIP 11/07/06

CUSTOMER ORDER NO.: N18484  
CUSTOMER PART NO: V872082

**EXTRUDEX**  
ALUMINUM  
**MILL TEST REPORT**

CUSTOMER: 1

SAMPLE (S) OF ALUMINUM

REPORT: 46131

DIE NO. S-18814  
DESCRIPTION 4"X4"X3/8" T-BAR 22'1"  
AL. ALLOY & TEMPER 6061/T6  
EXTRUDEX ORDER NO. 83775-5-A.11  
SPECIFICATION ASTM B221  
SILICON % 0.57  
IRON % 0.17  
COPPER % 0.20  
MANGANESE % <0.01  
MAGNESIUM % 0.84  
CHROMIUM % 0.08  
ZINC % <0.01  
TITANIUM % <0.01  
ALUMINUM % REMAINDER  
ALLOY TYPE % 6061  
ALLOY CAST NO. 28A637  
YIELD STRENGTH (IN ksi) 38.0  
TENSILE STRENGTH (IN ksi) 42.5  
ELONGATION % IN 2" 17.5  
HARDNESS (ROCKWELL 'F') 85.8  
85.3  
86.2

N. RAMPERTAB  
(LAB. TECH.)  
JULY-12-08

DATE:

411 Christie Road, Woodbridge, Ontario L4L 8M4 TEL: (416) 745-4444 FAX: (416) 745-0825